

Date: Tuesday, 16/12/2008 1:41:22 PM  
 User: Julie Dawson

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D3630-041  
 Job Number : 44113 *AR*  
 Estimate Number : 10804  
 P.O. Number :  
 This Issue : 16/12/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : REWORK20 *D3630-041*  
 Drawing Number : NCR08-122  
 Project Number :  
 First Issue : // Type : SMALL / MED FAB Drawing Revision :  
 Material :  
 Previous Run : 00015 Due Date : 23/12/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : *JLD 08.12.16*  
 Comment :

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D3630041 Cyclic Stick



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
 Cyclic Stick

Remove from stock:

Qty: *4* B *37120*

Qty: B

Qty: B

*08.12.16* ①

2.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure all dimensions are as per the drawing.

*08.12.16* ①

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Fill the affected 0.189" holes with weld on the D3630-1

Grind flush, and ensure there is no weld on the inside wall of the tubing.

*08.12.16* ①

4.0 QC10 VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

*08.12.16* ①

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill the 0.189" hole as per dwg on the D3630-1.

Debur inside and out.

*08.12.17* ①

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Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D3630-041

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Part Number: REWORK20

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure all other dimensions are as per the drawing.

08.12.17 (1)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify the parts with the new batch # and return to stock.

Location: \_\_\_\_\_

08.12.17 (1)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/17

Job Completion



MF-08-12-17

0

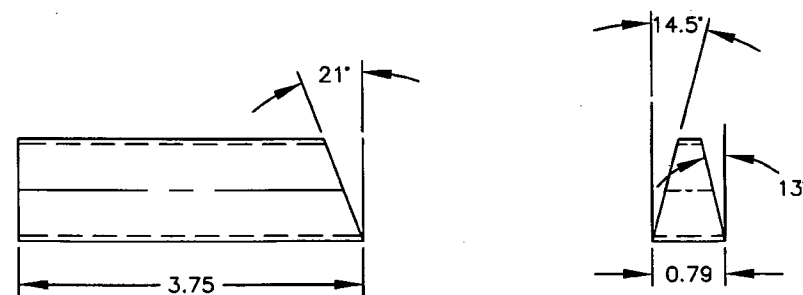
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

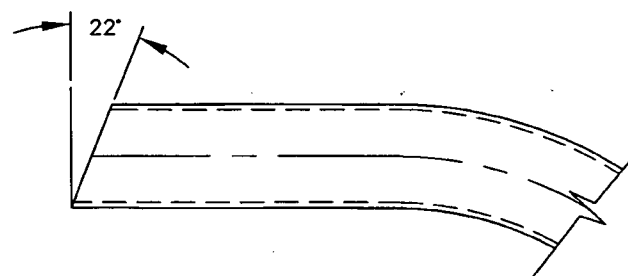
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D3630-3**  
(REPLACES GENEVA P/N G10202-2)




### DETAIL A: CUTOUT

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS  
ROUND TUBING 1.125" OD X 0.065" WALL  
(REF. DART SPEC M304TR1.125W.065)
- 2) FINISH: NONE
- 3) REFER TO TEMPLATE DT8940
- 4) WELD PER DART QSI 004
- 5) DRILL  $\varnothing 0.234$  THRU BOTH WALLS  
THEN DRILL  $\varnothing 0.257$  THRU ONE WALL AS SHOWN
- 6) DRILL  $\varnothing 0.189$  THRU BOTH WALLS  
AT 25" OFF HORIZONTAL AXIS AS SHOWN
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 8) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 9) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 10) IDENTIFY WITH DART P/N "D3630-041" USING FINE POINT  
PERMANENT INK MARKER

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A	07.05.11	NEW ISSUE: REPLACES G10202	
DESIGN CLB	DRAWN BY <i>SC</i>	 <b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3630	REV. A SHEET 1 OF 1
DATE 07.05.11		TITLE CYCLIC STICK	SCALE 1:2

RELEASED  
07-11-29 *MD*